

# Work Order ID 53464

November 6, 2009 8:23:04 AM



Page 1

Item ID:	D2857-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Hinge Bracket					
Start Date:	05/11/2009	Start Qty:	12.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>B1</u>	Date:	<u>09/11/19</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2857	Rev B								

100		BAND SAW	0.00						
	Bandsaw	Memo	0.00	JL	09/11/19				
	Jeaspa Bandsaw	Cut blanks 5.2"							
110		HAAS CNC VERTICAL MACHINING #1	0.00						
	HAAS 1	Memo	0.00	DIT	09/11/19	12			PTO
	HAAS CNC vertical machine #1	1-Machine per folio D2857-1 □ 2-Deburr any rough edges							
120		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00	DIT	09/11/19	12			
	Quality Control								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-1 PAR #: \_\_\_\_\_ Fault Category: Unchained parts NCR: Yes No DQA: 7 Date: 09-11-30  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7 Date: 09-11-30

NCR: <u>53464</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/19	110	first part dim. 0.147" is 0.134" (0.003 under tol.) IA correct offset RC LOA	CP 09/11/20 per QSI 042	Raise offset H14 0.0065 SCRAP PART AND REPLACE BATCH # 110936	DJP 09/11/19	SL 09/11/20 per QSI 042	CP 09/11/20 per QSI 042	S 01/12/20

NOTE: Date & initial all entries

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Item ID: D2857-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	SF 09/4/20			12	<del>1</del>		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	AL 09/11/23			X12	<del>0</del>		
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	2) S07/11/23						



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Item ID: D2857-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Hinge Bracket

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25

12/09/11-24  
(12)

# Picklist Print

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Work Order ID: 53464



Parent Item: D2857-1RevB



Parent Item Name: Hinge Bracket

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	30.8000	5.5263			



6061-T6 Bar 2.00 x 1.25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	30.8	
105838	12	
110936	18.8	

5.526

SL 09/11/19

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53464
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2857-1
<b>Inspection Dwg:</b> D2857	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.307	✓			
4.000	+/-0.010	4.004	✓			
0.340	+/-0.010	0.339	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.792	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.003	✓			
0.340	+/-0.010	0.342	✓			
0.447	+/-0.010	0.447	✓			
Ø0.171	+0.005/-0.000	0.174	✓			
0.147	+/-0.010	0.143	✓			
0.376	+/-0.010	0.375	✓			
0.126	+/-0.010	0.126	✓			
0.063	+/-0.010	0.060	✓			
Ø0.166	+0.005/-0.000	0.167	✓			
0.911	+/-0.010	0.914	✓			
0.600	+/-0.010	0.607	✓			REF
0.125	+/-0.010	0.132	✓			
0.150	+/-0.010	0.147	✓			

<b>Measured by:</b>	DJP
<b>Date:</b>	09/11/19

<b>Audited by:</b>	JB
<b>Date:</b>	09/11/20

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

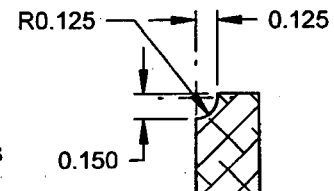
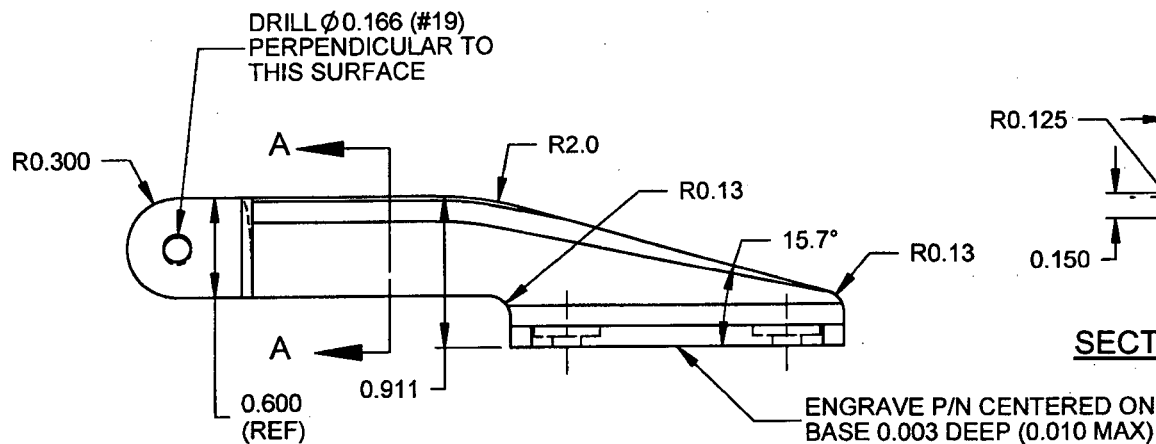
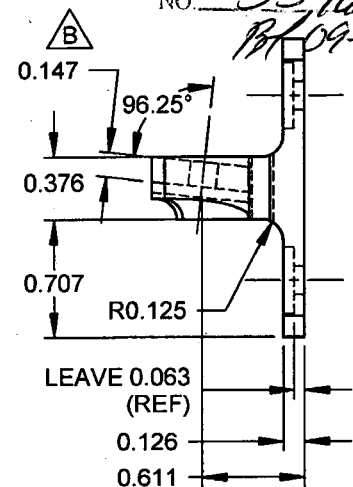
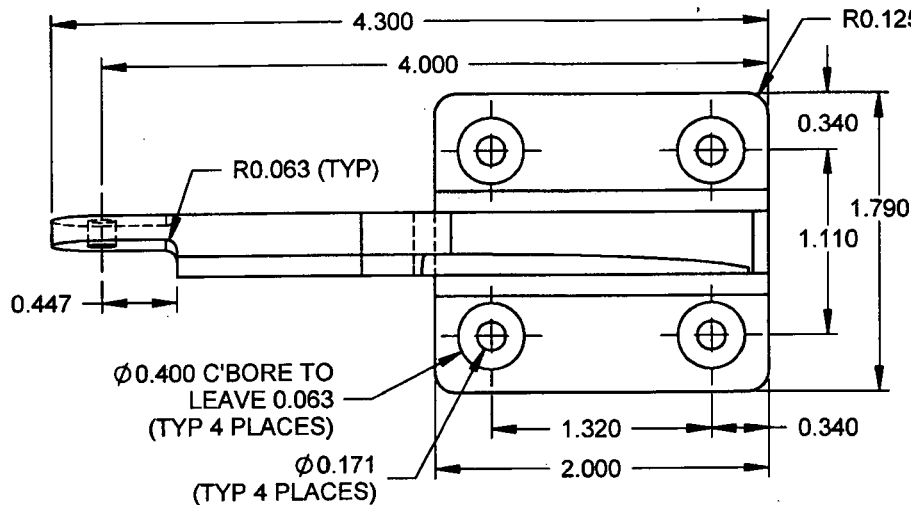
Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

**DART**

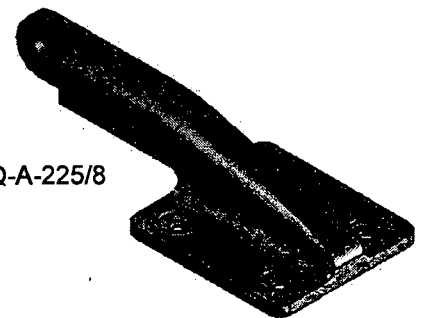
DESIGN KE	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2857</b>	REV. B SHEET 1 OF 1
DATE <b>06.08.28</b>	TITLE <b>HINGE BRACKET</b>	SCALE 1:1	
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	

**RELEASED**  
06-10-13

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *53464*  
*PT 109-1-5*

**SECTION A-A****D2857-1 HINGE BRACKET**  
**D2857-2 OPPOSITE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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